

Date: Thursday, 08/03/2007 1:16:38 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	: 31031A		
Estimate Number	: 10839		
P.O. Number	: <i>N/A</i>	Part Number	: D22491
This Issue	: 08/03/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2249 REV. E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 07/03/2007 Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: <i>N/A</i>	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 10/04/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	10 Um: Each
Comment	: Est: D 05.02.04 Added Step 9 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304S16GA	304/316 .063 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.0903 sf(s)/Unit Total : 0.9030 sf(s)

304/316 .063 Sheet

Batch: *M101463*

ML 07 03 14

(10)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D2249

Dwg Rev: *E*

Prog Rev: *E*

ML 07 03 14

(10)

2-Deburr if necessary

> ML 07/03/14 -x10

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 07 03 14

(10)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

0703.14 (10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *N/A*

FL 07 03 22 (10)

Date: Thursday, 08/03/2007 1:16:38 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31031A

Part Number: D22491

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(10)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07/03/23

Job Completion



u 07-03-23

[illegible][illegible]

~~PURCHASING~~



Material release note required

780-51667

Lug



PACKAGING RESOURCE #1



Ensure Material Release Note is attached

DIMENSIONAL CHECK



Inspect dimensions as per template D2249-1T1 & Dwg D2249

SMALL & MEDIUM FAB RESOURCE 1



1-Deburr any rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:38:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31031A

Part Number: D22491

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

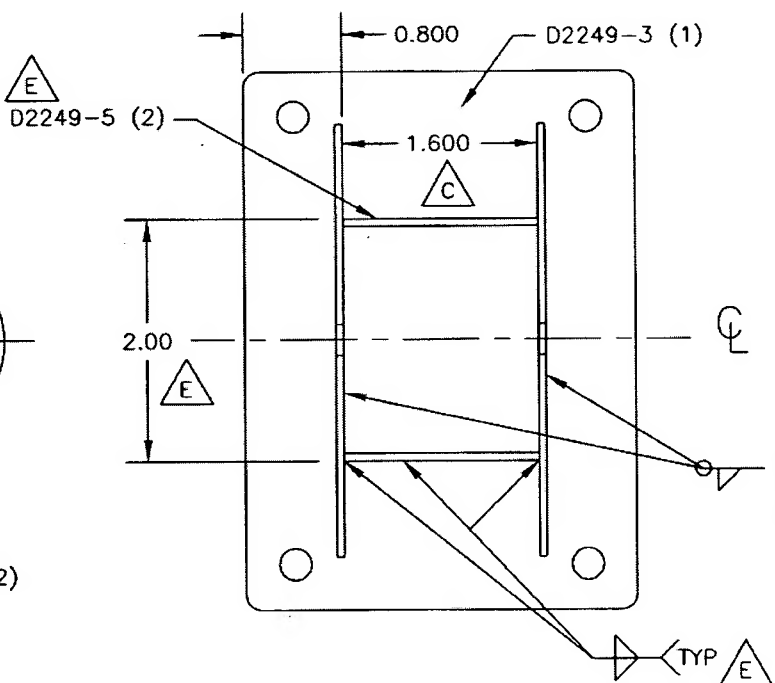
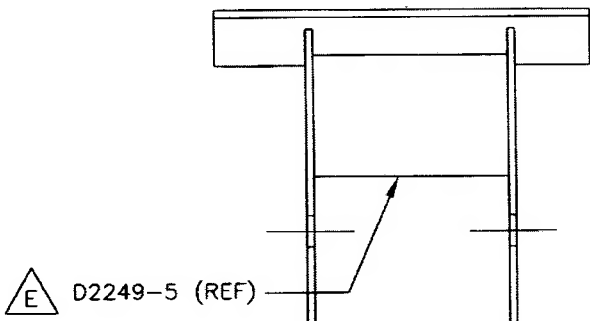
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

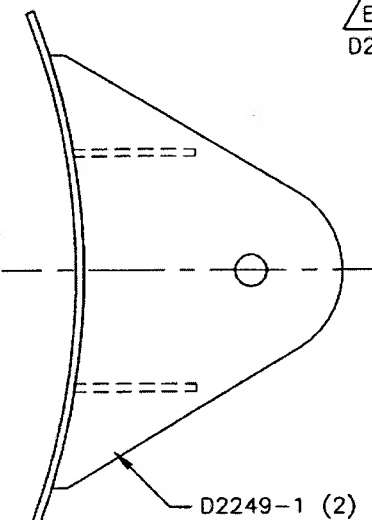
NOTE: Date & initial all entries

DART**RELEASED**
99.10.12 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
AE	RF	DRAWING NO.	REV. E
KE	KE	D2249	SHEET 1 OF 4
DATE		TITLE	SCALE
99.09.20		FITTING	NTS
A	94.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	DIMENSION CHANGE	
D	98.04.30	Ø0.261 WAS Ø0.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	

**D2249-041 ASSEMBLY**

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED



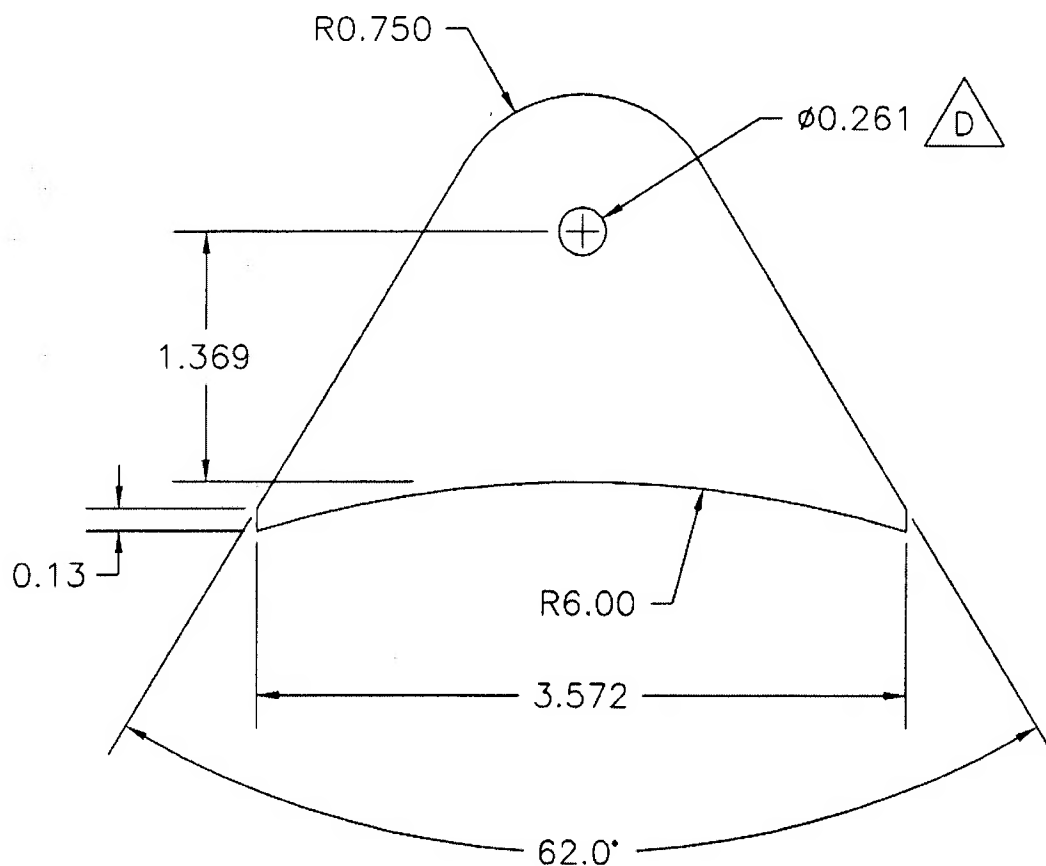
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
21031A



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

RELEASED
99.10.12 *KE*



D2249-1 LUG

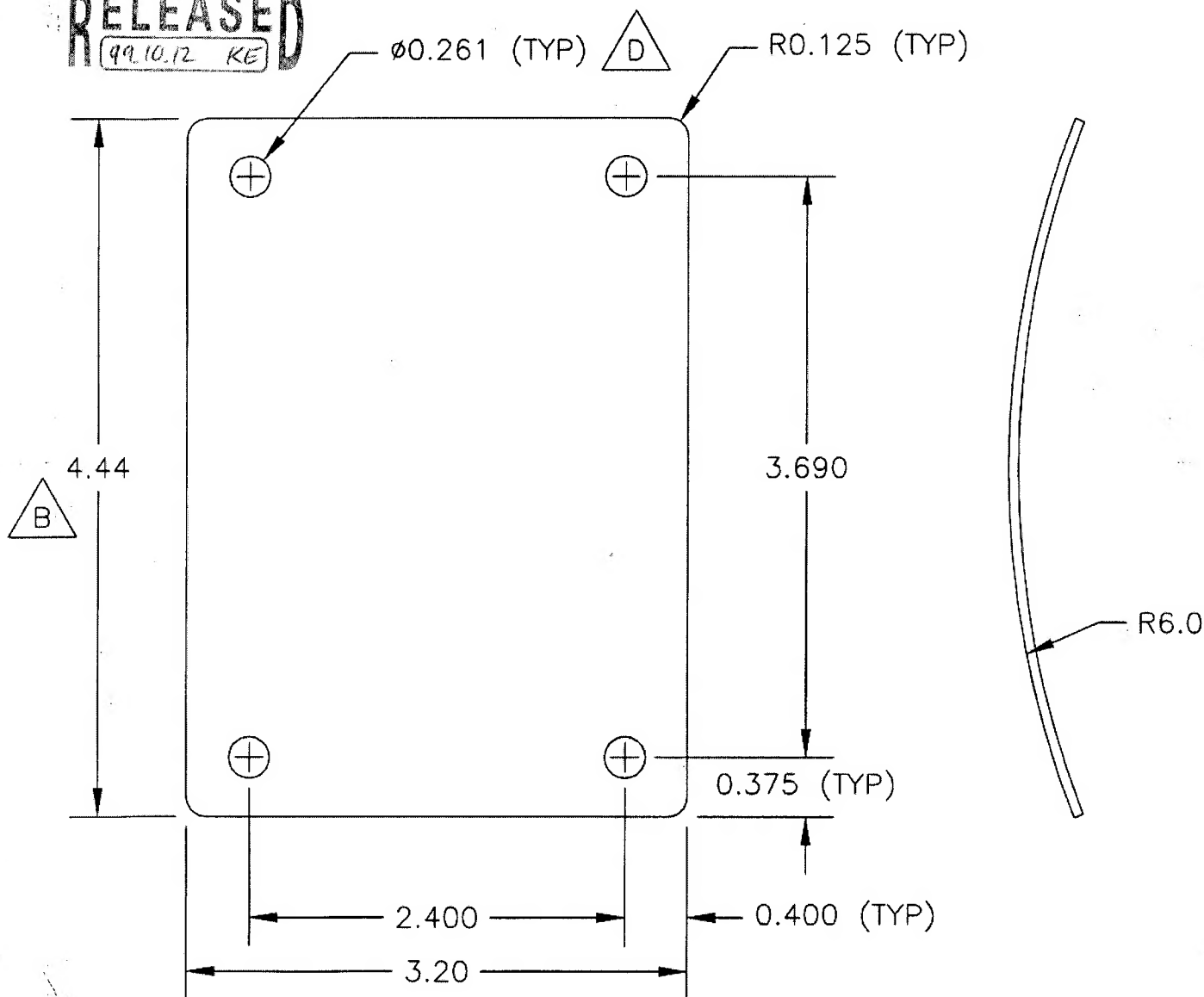
MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

RELEASED
99.10.12 KE



FLAT PATTERN

D2249-3 BASE PLATE

BEND DETAIL

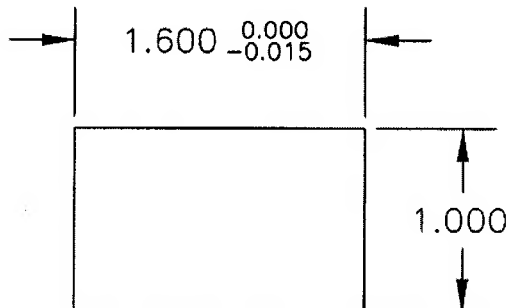
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WORK ORDER
NO. 31031A

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
19.10.12 *KE*



D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

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